

Date: Wednesday, 6/6/2007 1:38:09 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 EXTRUSION BENDING
Job Number	: 32754		
Estimate Number	: 10311		
P.O. Number	: N/A	Part Number	: D2620
This Issue	: 6/6/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2620 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 32449	Drawing Revision	: B
		Material	: N/A
Written By	:	Due Date	: 6/20/2007
Checked & Approved By	:	Qty:	20 Um: Each
Comment	: Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D26001160	Extrusion Round 3" 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Extrusion Round 3" 206

Pick;

Qty	Part Number	Description	Batch
1	D2600-1	Extrusion Round 3"206	30249

EL 7-6-12

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008

2- Cut Fwd end of tube as per Dwg D2620

EL 7-8-12

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

BE

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

BE 07-06-14

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



20  
07/07/06  
U A. A. A.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

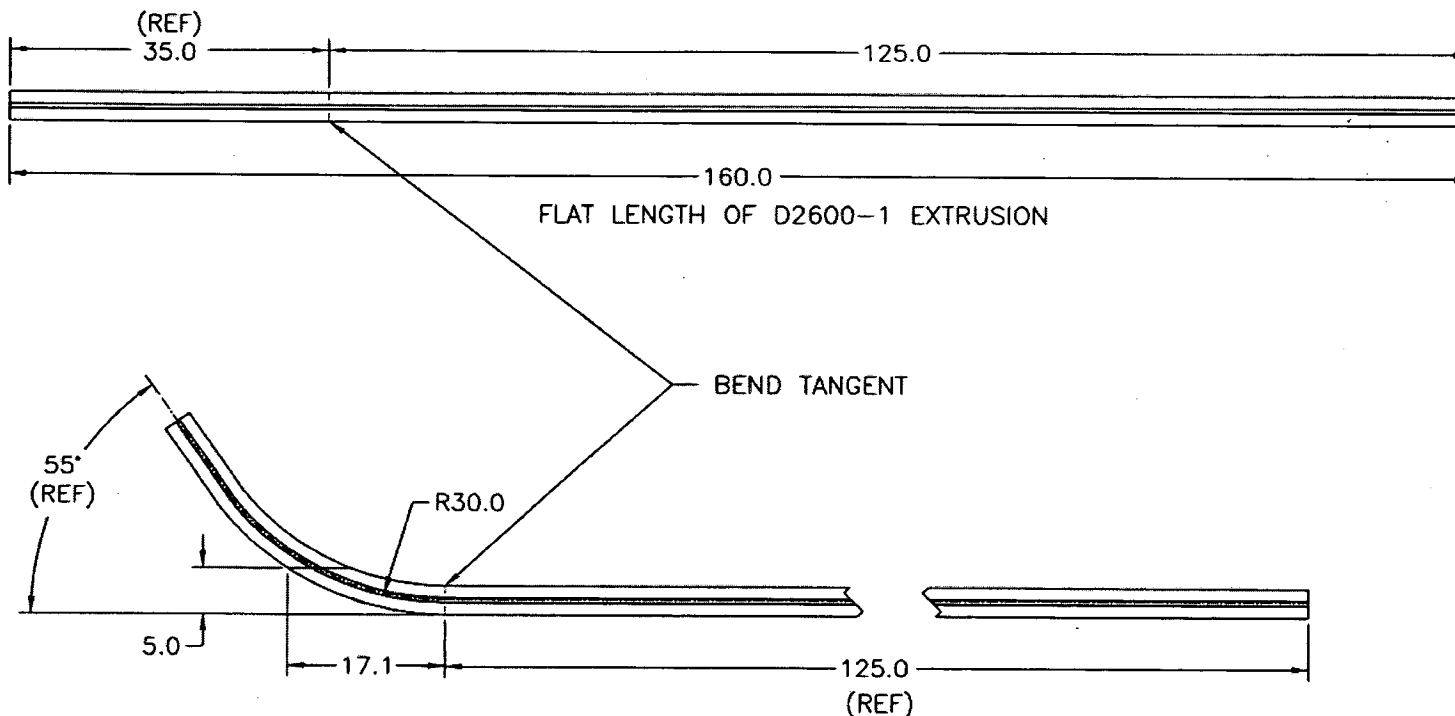
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 12 Date: 9/17/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# SPECIFICATION CONTROL DRAWING

## 206 SKIDTUBE BENDING



### DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE  $3.20 \pm 0.200$  IN THE BEND. TUBE WIDTH SHOULD BE  $3.200 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE  $3.15 \pm 0.200$  IN THE BEND. TUBE HEIGHT SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	TITLE	REV. B
99.09.10	206 SKIDTUBE BENDING CONTROL	SHEET 1 OF 1
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING

RELEASED  
99.04.15 D5

